

# Work Order ID 56914

March 12, 2010 1:29:01 PM



Page 1

Item ID: D3706-5

Accept



Setup Start



Revision ID:

Item Name: Pin

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

14

Date: 10-3-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3706

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA756 Rev:     & Dwg D3706 Rev: A □2- SL 10/03/22

Deburr per dwg D3706

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/03/22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 10/03/22

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56914

March 12, 2010 1:29:01 PM



Page 2

Item ID: D3706-5

Accept



Setup Start



Revision ID:

Item Name: Pin

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per dwg D3706								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	1- drill hole as per dwg D3706								

SD 10/04/21

SD 10/04/22

(X5)

Ph →

N/A 10-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3706-5 PAR #: \_\_\_\_\_ Fault Category: Small Pals NCR: (Yes) No DQA: [Signature] Date: 10/04/21  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/04/27

NCR: <u>56914</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/21</u>	<u>130</u>	<u>5 pieces broke</u> <u>while Bending the 1/8"</u> <u>RAD.</u> <u>R.C. process</u> <u>1st time?</u> <u>5 broke out of batch!?</u>	<u>[Signature]</u> <u>12/21/22</u>	<u>-Scrap + destroy Qty x5</u> <u>Material certs were reviewed</u> <u>and are correct.</u>	<u>[Signature]</u> <u>10/04/21</u>	<u>[Signature]</u> <u>10/04/22</u>	<u>[Signature]</u> <u>12/21/22</u>	<u>[Signature]</u> <u>10/01/31</u>

NOTE: Date & initial all entries

# Work Order ID 56914

March 12, 2010 1:29:01 PM



Page 3

Item ID: D3706-5

Accept



Setup Start



Revision ID:

Item Name: Pin

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	N/A. <i>10.03.20</i>						
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>ST 84</i>  Memo	0.00  0.00	<i>m-h 10/04/28</i>						
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00	<i>10/04/27</i> <i>MF</i> <i>10-4-26</i>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 31, 2010 11:24:02 AM

Page 1

Work Order ID: 56914



Parent Item: D3706-5



Parent Item Name: Pin



Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A New Issue 08-05-30 EC Verified By:DD

Start Qty: 10.00

Required Qty: 10.00

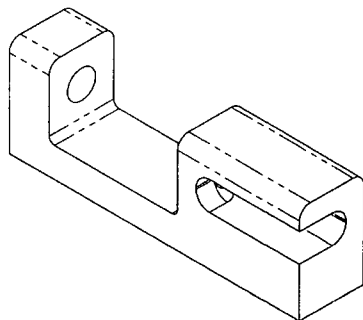
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R0.313		Purchased	No				f	31.6425	0.4000			
												
303 ROUND BAR .313												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT028	31.6425	
108220	3.24	
110551	3.3825	
111787	25.02	

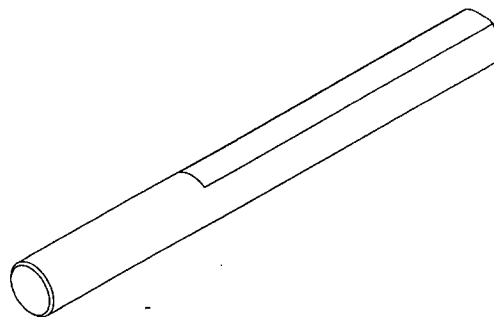
-500 JK 10/03/22



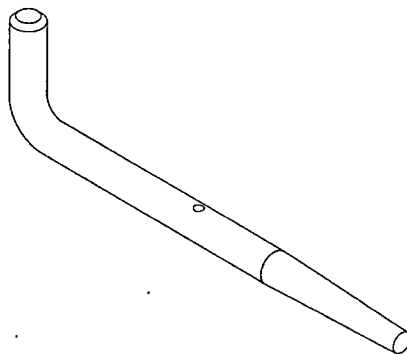




D3706-1 LOCK BRACKET



D3706-3 GUIDE

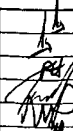


D3706-5 PIN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 56914

210-3-15

**RELEASED**  
09/02/05 MJD

A	NEW ISSUE		M9	08.05.26
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3706		SHEET 1 OF 1
APPROVED		TITLE		SCALE
DE APPR.		INSTRUMENT PANEL LOCK		NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

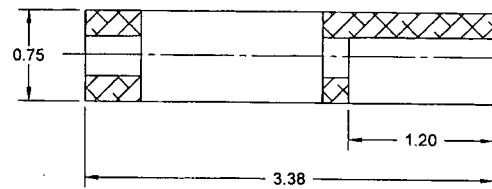
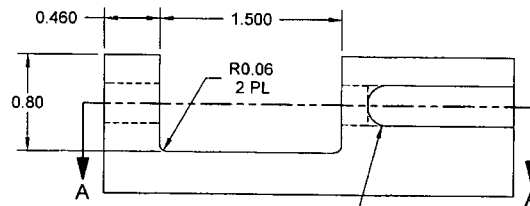
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

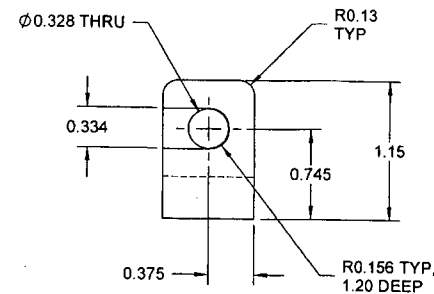
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **SECTION A-A**

## **D3706-1 LOCK BRACKET**



*w/lo 56914*

**RELEASED**  
*9/26/05 NFB*

### **D3706-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T6511/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>LB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JB</i>	<b>D3706</b>	SHEET 2 OF 4
APPROVED	<i>JB</i>	TITLE	SCALE
DE APPR.	<i>JB</i>	<b>INSTRUMENT PANEL LOCK</b>	NTS
DATE	<b>08.05.26</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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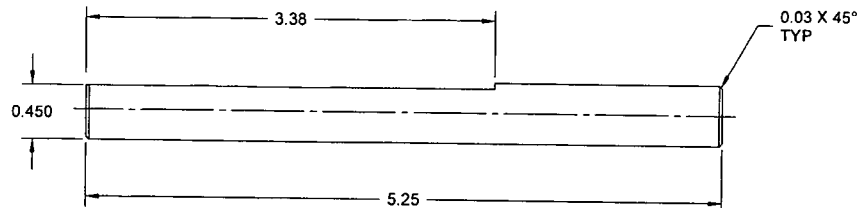
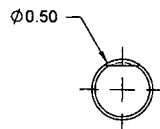
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3706-3 GUIDE**

W/O 56914

**RELEASED**  
09/02/05

## **D3706-3 GUIDE NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6R0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3706	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL LOCK	NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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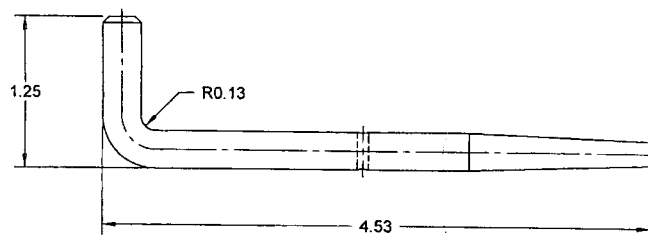
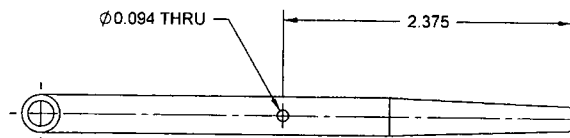
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

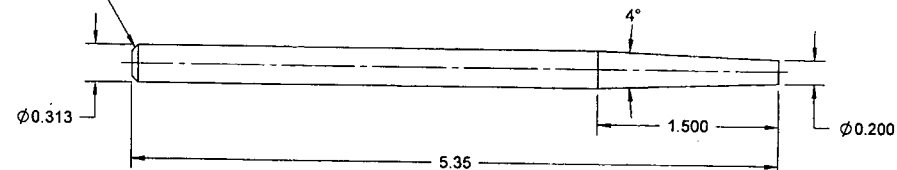
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3706-5 PIN**  
(MAKE FROM D3706-5F)

0.05 X 45°  
CHAMFER



**D3706-5F PIN**

u/0 56914

RELEASED  
07/05/11

**D3706-5 NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR  
(REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3706	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL LOCK	NTS
DATE	08.05.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

2.324

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Supplier: msbnsDart P/O: 7927
 Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

 Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒  
 Shipment Complete: Yes ☐ No ☒ N/A ☐  
 QCS Inspection: ☒ N/A ☐  
 Work Order: 0910189 N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
MN4B02000000		24	0	0	24	
M6048TG30700404		120	0	0	120	
M6061T65050		192	0	0	192	

Initials of receiver (if shipment OK) Level 12                     

Production/Admin:

Date

Received/Costing

Initial

09.01.19  
RCP9992  
JW
Location                     

H:\FORMS\Purchasing\approved purch\RECREPORT R v D

REFERENCE ONLY

L019382 10 PC/840 LB

RECEIVED JAN 22 2009

01/19/09 15:29:39

Merchandise:	2,455.50
Surcharges:	
No Tax Costs:	
GST	122.78
Total Due:	2,578.28

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

 Q.S.T. # 1213236471  
 G.S.T. # 881565899 RT0001

# DART

## Purchase Order

Date	Page
Jan 15, 2009	1
Purchase Order Number PO00007977	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FAKED**  
6/9/11/5

**Vendor Address:**

Magna Stainless  
5775 rue Kieran  
St Laurent, Quebec H4S 0A3  
Canada  
Phone (514) 339-1211  
Fax (514) 339-1105

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 15, 2009	N30	yours	Jan 21, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
24.0000	M174B0250X4000	17-4 SS Bar .250 X 4.00 Comments: MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 GRAIN MUST BE ALONG LENGTH OF BAR MINIMUM YIELD TENSILE STRENGTH = 100KSI MINIMUM ULTIMATE TENSILE STRENGTH = 150KSI	21/01/2009	No	27.083333	Ft	650.00
12.0000 <i>New 12-7</i>	M303R0313 ✓	303 ROUND BAR .313 Comments: MATERIAL: AISI 303 ROUND BAR (NOTE: AISI 304/316 NOT ACCEPTABLE)	16/01/2009	No	0.791666	f	9.50
✓ 320.0000	M304S16GA	304/316 Sheet .063 Comments: MATERIAL: AISI 304/316 SS SHEET AS PER AMS 5513 OR 5524	21/01/2009	No	5.781250	sf	1.850.00
120.0000	M6061T6B0750X001	6061-T6 Bar .750 x .125 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6511/T6510/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	16/01/2009	No	0.416666	f	50.00
192.0000	M6061T6S080	6061-T6 .080 Sheet Comments: MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027	21/01/2009	No	6.145833	sf	1.180.00
* 192.0000	M6061T6S063 ✓	6061-T6 .063 Sheet Comments: AS ABOVE * P.S (REQUIRED MATERIAL FOR FRIDAY THE 16 OF JANUARY)	16/01/2009	No	3.104166	sf	596.00

**Comments:****Tax Summary:**

GST 216.78  
ONTPST 0.00

**Less:**

included tax

0.00

Subtotal

4,335.50

Total tax

216.78

Total purchase order in

CAD Dollars

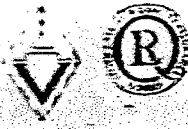
4,552.28

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

Entered By: *CZ* CLAVOIE

Approved By: *W*

# Acciaierie Valbruna S.p.A.



**CERTIFICATO DI COLLAUDO**  
**ABNAHMEPRUEFZEUGNIS**  
**INSPECTION CERTIFICATE**  
**CERTIFICAT DE RECEPTION**  
**EN 10204 (2005) , 3.1**

36100 VICENZA (Italia) - Viale dell'Industria 25  
Stab.: 39100 BOLZANO (Italia) - Via A. Manzoni 3

Cliente / Besteller/Kunde/Klient  
VALBRUNA CANADA LTD  
8724 HOLLGATE CRESCENT  
CDN-MILTON, ONT L5T 5Z1-CAN

Aut. di Spedizione: D-VI08023633  
Contratto/Contrat/Nr. 1051

Certificato nr: MEST668292/2008/  
Prüfung/Test/Essai

Conferma ordine nr: EI08003212  
Werk/Our Order/Nr.

Produttore: ACCIAIERIE VALBRUNA S.P.A.  
Hersteller/Hersteller/Usine producteur

Ordine nr: 604001955  
Bestell/Nr./order/Commande

Marchio di Fabbrica:  
Zeichen des Unternehmens  
Trade mark  
Sigle de l'usine producteur



Oggetto Prove: - Annealed Cold Drawn  
Prüfgegenstand/Item inspected/Échantillon

Tipo di Elaborazione: E+AOD  
Erzeugnisprozess/Manufacturing process/Mode d'élaboration

Punzone del Collaudatore:  
Stempel des Werkssachverständigen  
Inspector's stamp/Plombon de l'inspecteur



Specifiche:  
Anforderungen / Requirements / Exigences

VAL CANADA 2 303 A.C.F.  
ASTM A314 97 S30300  
DOD-F-24669 6 S30300  
(0) SEC.II PTA 2007 EDITICN

AMS 5640 U TYPE1  
ASTM A320 2008 B8F  
MIL-S-862 B/1 303

ASME SA320 2007 B8F (0)  
ASTM A582 2005 S30300  
QQ-S-764 B/2 303

OK

Qualità: T-303  
Werkstoff/Grade/Matériau

Marca: VPAU188Z VALPLUS  
Markenbezeichnung/Brand/Alors

Punzonatura: T-303  
Kennzeichnung/Marking/Marquage

Pos. nr. Post. nr. Nr. de posn.	Oggetto Objet Produit/Description	Dimensioni - in Dimensions Dimensions	Tolleranza Tolerance Tolérance	Lunghezza - R Länge Length Longueur	Colata Schmelze Heat Coulée	Pezzi Stückzahl Pieces Pièces	Peso - LB Gewicht Weight Poids	Lotto nr. Losn. Lot nr.
0010	Round	0,3125	484-06B	13 / 13	422176		17,320	810205730

Sono state soddisfatte tutte le condizioni richieste  
Die gestellten Anforderungen sind befriedigt  
The material has been examined in accordance with the requirements  
Le matériel a été trouvé conforme aux exigences

Controllo antiriscaldamento: OK  
Vorwärmungsprüfung: zufriedenstellend durchgeführt  
Antirising testing performed: OK  
Contrôle antiréchauffage fait: r.a.s.

Controllo visivo e dimensionale: soddisfa le esigenze  
Besichtigung und Ausmessung: ohne Beanstandung  
Visual inspection and dimensional check: satisfactory  
Contrôle visuel et dimensionnel: satisfaisant

TEST	Provetta Korndruck Longitudinale Durchmesser Werkst. nach Werkst. nach mm	°F	Prop. Sample Länge mm	Snervamento Streckgrenze Yield Stress Unter der Fließgrenze Rp 0,2% k.s.i.	Snervamento Streckgrenze Yield Stress Unter der Fließgrenze Rp 0,2% k.s.i.	Resistenza Zugfestigkeit Tensile strength Resistance à traction Rm k.s.i.	Allungamento Bruchdehnung Elongation Allongement E 4d %	Strizione Bruchdehnung Reduction of area Striction RA %	Resilienza Kerbschlagenergie Impact Value Resilience	Durezza Härte Hardness Dureté HB
Valori richiesti 1 Anforderungen/Required values Valeurs demandées		min max		30		75	35	50		140 241
A	7,93	68 L		87		114	38	53		239

1) L=longueur/length, Q=transverse/quer., T=longueur/tangentiel

## Analisi chimica

Chemische Zusammensetzung/Chemical Analysis/Analyse chimique

Colata Heat Schmelze/Heat	min - max 0,150	1,00	2,00	17,00 19,00	0,60	1,00	8,00 10,00	-	0,15	0,15 0,40	-	-	-	-	-
	C %	Si %	Mn %	Cr %	Mo %	Cu %	Ni %	Co %	P %	S %	-	-	-	-	-
422176	0,045	0,39	1,85	17,39	0,47	0,59	8,05	0,067	0,03	0,30					

Produced without class I-II Ozone depleting substances.  
Solution heat treated free from continuous carbide network.  
Annealing temperature: 1940°F for 0,5 h/water.  
Micro and macro etch test: OK  
Material is DFARS Compliant

Melted and manufactured in Italy No welding or weld repair Material free from Mercury or radio-activity contamination  
The Quality Management System is Certified acc. Pressure Equipment Directive (97/23/EC) Annex 1, a. 4.3 by TÜV and LLOYD'S

Vicenza, 11/09/08 VCO008 (Mod. MCER)	Il collaudatore di stabilimento / der Werkssachverständige / Works inspector / L'agent d'usine M. Rizzotto	Pagina -1 di 1
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